



Dart Aerospace Ltd.
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Canada

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D6025-120
Job Sheet 177706

Accounting Job RD17-1027-01



Part No: D6025-120

Job Qty: 17 pcs

Part Name: Crosstube Material



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/16/18

Job Tracking No:

Due Date: 5/30/18

Created By: Michelle Gagnon-Donovan

Type: R+D

Description:

Note: TBD D6025 REV.C IPP REV:A 16.09.16 NEW ISSUE DD VERF:JFS IPP REV:B 17.12.14 AS PER DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
160	Rework Start up	17 Ea		5/30/18	0.00	0.00	Start Up Machining-3		
170	Rework	17 pcs		5/30/18	0.00	0.00	Crosstubes-2		
180	Rework	17 pcs		5/30/18	0.00	0.00	QC5		
190	Rework	17 pcs		5/30/18	0.00	0.00	Outsource1		
200	Rework	17 pcs		5/30/18	0.00	0.00	Packaging2		
210	Rework	17 pcs		5/30/18	0.00	0.00	QC6		
220	Rework	17 pcs		5/30/18	0.00	0.00	Packaging3		
230	Rework	17 pcs		5/30/18	0.00	0.00	QC21		

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6025-120	Crosstube Material	17 Ea (1 ea)	160-Rework Start up	160049

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
160-Rework Start up	D6025-120	17	17	0

Part Specifications

Specifications could not be found.

Plex 5/16/18 1:50 PM Dart.Gagnon.Michelle

→ 190 Outsource Heat Treat P/O : Met Lab PO #39906
Heat Treat to T73 condition per AMS 2770 as per drawing
~~CoFC~~ is Required.
CoFC



Container No: S072220



Part: D6025-120

Job No: 177706

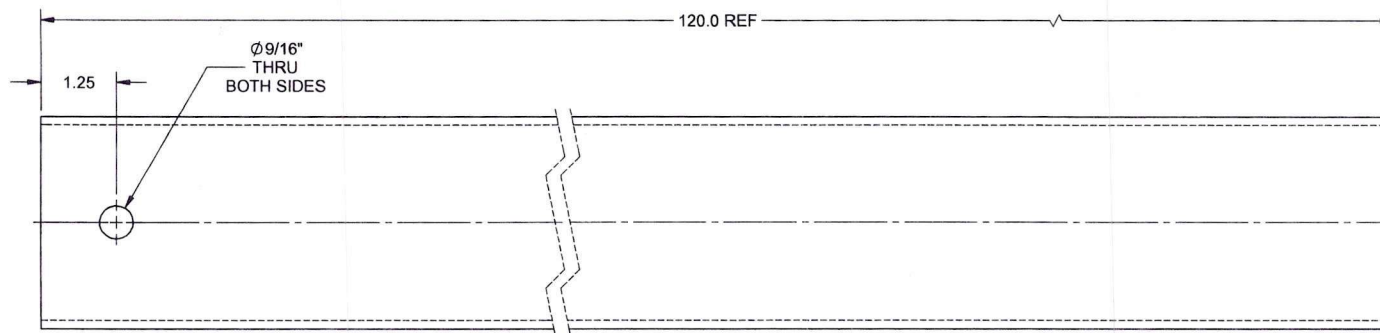
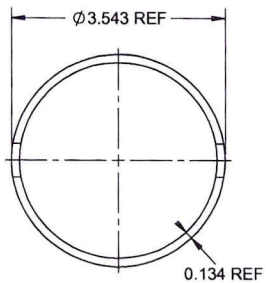
Serial No/Batch: S072220

Revision: C

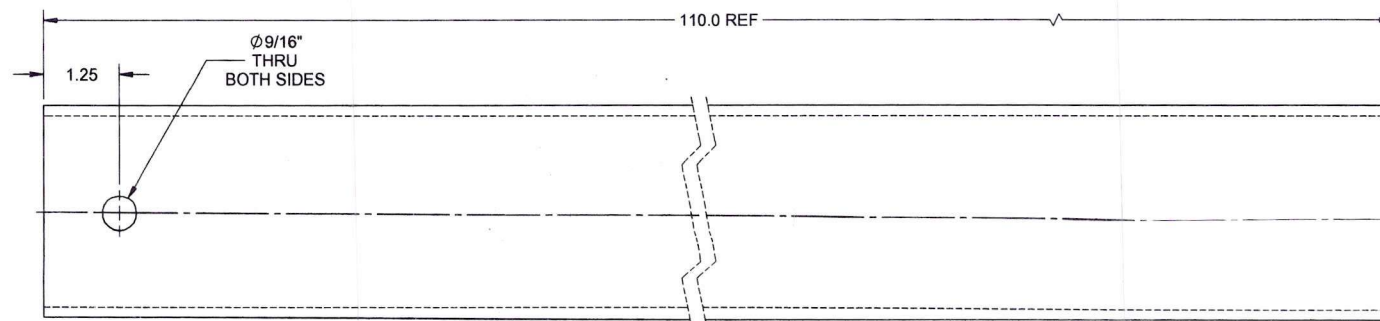
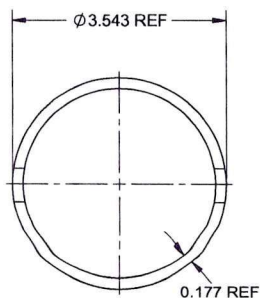
Inspector:

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www.dartaerospace.com

Date: 05/17/18



DSK170-5 DRILLED TUBE



DSK170-7 DRILLED TUBE

NOTES:

- 1) MATERIAL: DSK170-5: MAKE FROM D6025-120
DSK170-7: MAKE FROM D6026-110
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: N/A
- 8) HEAT TREAT TO T73 CONDITION PER AMS 2770
MINIMUM ULTIMATE TENSILE STRENGTH = 66 KSI
MINIMUM YIELD TENSILE STRENGTH = 56 KSI
MINIMUM ELONGATION = 12%

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DESIGN	ZF	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSK 170	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PLUG	NTS
DATE	18.05.15	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>177710</u> Part No. <u>D6026-110</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☒ Water Jet ☐ Supplier Quality ☐			
Date: <u>18/5/16</u>	Sequence #: _____	QTY Affected: _____		MRB (QSI042) <u>INSP 12 18/5/16</u>	
Description Work Order Deviation		Disposition			
<u>D6026-110 5160060 was received in TO condition.</u>		<u>Acceptable to heat treat material to T73 condition per AMS 2770. Ensure material properties and dimensions are per dwg D6025 following heat treatment. Acceptable to drill material for tooling holes at one end in portion removed during cross tube fabrication.</u>		Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details: _____			